

Work Order ID 143653

March 17, 2016 2:22:37 PM

143653

Page 1

Item ID: D3781-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Armrest Cushion Assembly
 Start Date: 3/18/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/1/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: SA Date: 20160318 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3781	E

100 0.00 ***100*** **DAS**
 Purchasing 0.00 **13**
9-89
4 MAR 22 2016

Memo
 Issue P/O: 31272
 Ship with D3785-1 SUPPORTING PLATE
 Material: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT) AND COVER
 D3781-5/D3785-1 ASSEMBLY WITH SURREY SILVER SUNSET
 UPHOLSTERY FABRIC P/N SY-111. BOND D3781-5 TO D3785-1 AND
 FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN
 ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS. DO NOT
 COVER HOLES WITH FABRIC
 THREAD: MIL-VT-295 TYPE2 CLASS A, GREY NYLON THREAD, 4-6
 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS.
 Possible Supplier: AEROTEX INTERIORS INC.
 Material release note is required

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging

CZ 16/03/31 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 143653

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143653

Page 2

Item ID: D3781-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Armrest Cushion Assembly
Start Date: 3/18/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/1/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							DAS 38 9-88
120									
QC	Memo	0.00							
Quality Control									APR 01 2016
130	Identify as per dwg & Stock Location: <u>5438</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									APR 01 2016
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									APR 05 2016

APR 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY			
Environment ☐		No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐		Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐		Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐		Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐		Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐		Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐		Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐		Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐		Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐		Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐		Past Due ☐				

Picklist Print

March 17, 2016 2:22:41 PM

Page 1

Work Order ID: 143653

143653

Parent Item: D3781-043

D3781-043

Parent Item Name: Armrest Cushion Assembly

Start Date: 3/18/2016

Required Date: 4/1/2016

Start Qty: 4.00

Required Qty: 4.00

Comments:

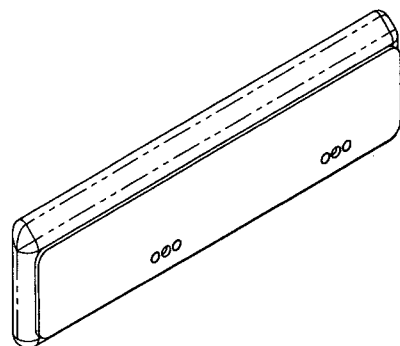
IPP RevA: New issue DD verified by:EC

IPP Rev:B

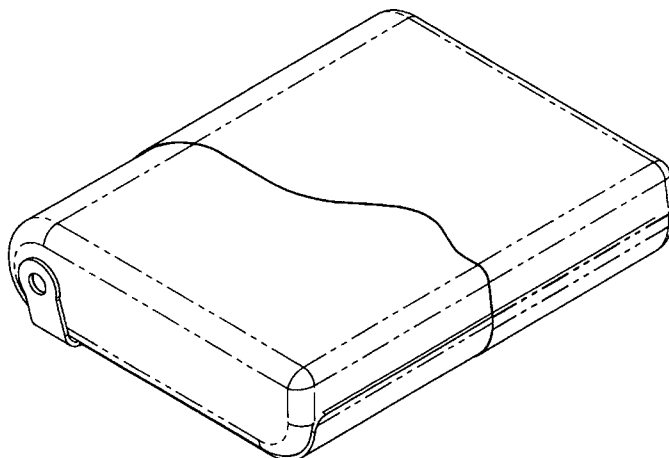
09-05-15 As per ECN09-593P JLM Verified By:EC IPP Rev:C as per dwg

RevE DD 10.04.27 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3785-1 *D3785-1* Bracket		Manufactured	No			100	Each	7.0000	1	4			
									**	DAS 13 9-89		MAR 22 2016	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST459				7					
					56935			7					
D3781-043P *D3781-043P* Armrest Cushion Ass'y		Purchased	No			110	Each	0.0000	1	4			
									**			MAR 31 2016	DAS 13 9-89



D3781-041 LATERAL CUSHION ASSY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



D3781-043 ARMREST CUSHION
(UPHOLSTERY FABRIC NOT SHOWN PARTIALLY FOR CLARITY)

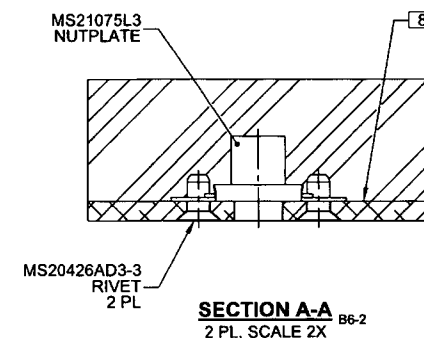
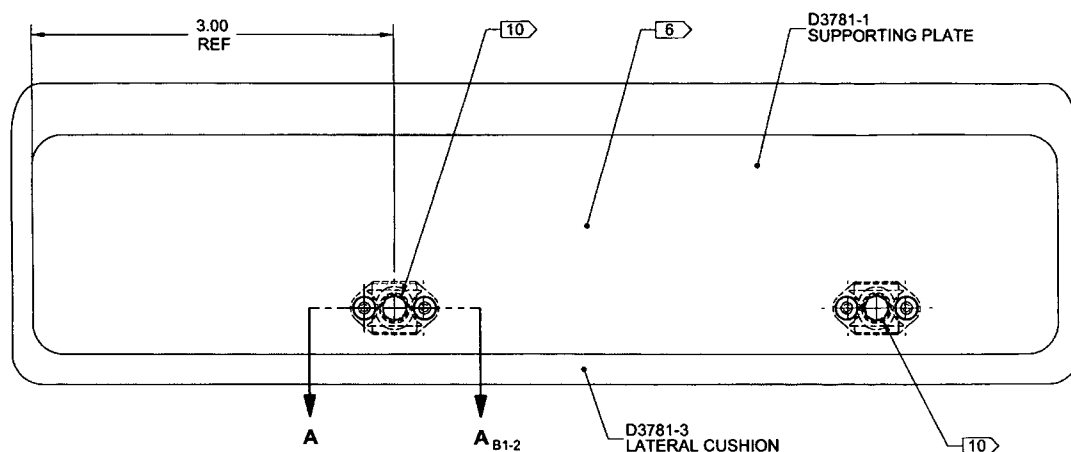
RELEASED
2010-04-26

20160318

SW 143653

REV.	DESCRIPTION	BY	DATE
E	REMOVED ZIPPER FROM D3781-043. SHEET 3 REVISED ACCORDINGLY. REASON: MANUFACTURABILITY PER NCR 10-012.	MB	10.04.14
D	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.21
C	REDESIGNED FOR COMPATIBILITY WITH BHT 204 SEATS	MB	08.11.10
B	REDESIGNED; ADDED DETAIL A (ZN B7-1)	MB	08.07.15
A	NEW ISSUE	MB	08.04.29
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		DRAWING NO. D3781	REV. E
CHECKED		TITLE	SHEET 1 OF 6
MFG. APPR.		CUSHION ASSEMBLY	SCALE
APPROVED			NTS
DE APPR.			
DATE	10.04.14	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3781-041	CUSHION ASSEMBLY
11	1	D3781-1	SUPPORTING PLATE
12	1	D3781-3	LATERAL CUSHION
22	2	MS21075L3	NUT PLATE (OR MS21075-3)
23	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
24	A/R	1300	3M SCOTCH-GRIP ADHESIVE
25	4	MS20426AD3-3	RIVET



D3781-041 LATERAL CUSHION ASSEMBLY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)

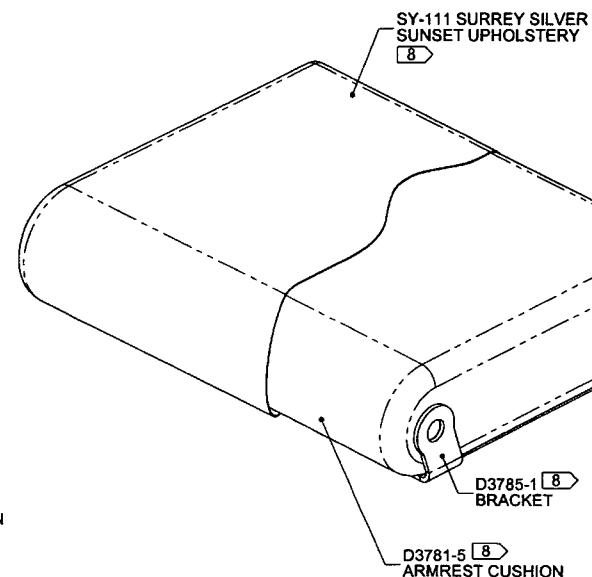
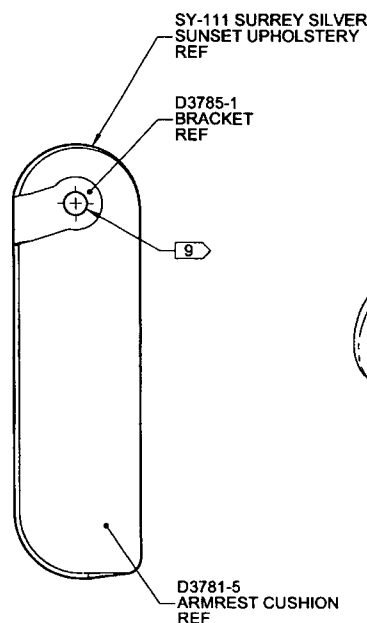
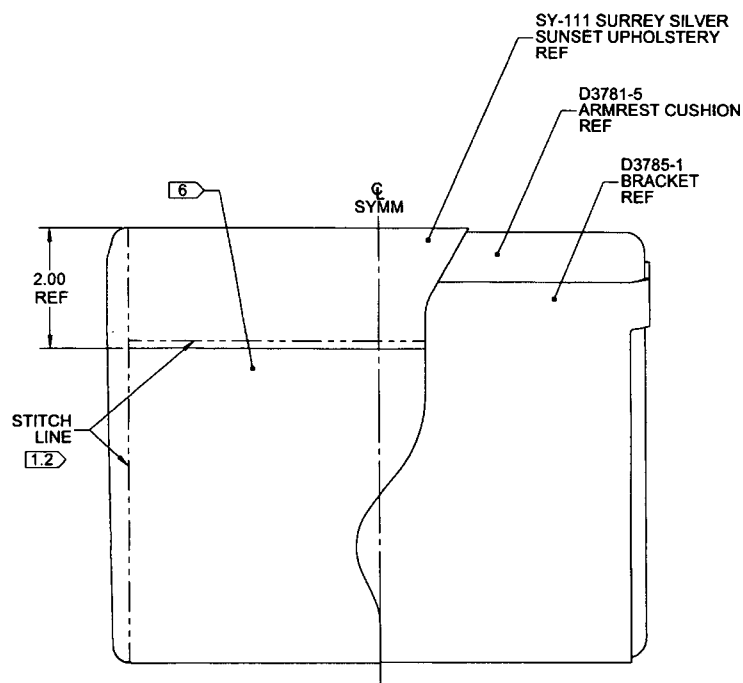
D3781-041 NOTES:

- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH
MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH
D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

RELEASED
2010-04-26

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3781	REV. E
MFG. APPR.			SHEET 2 OF 6
APPROVED		TITLE CUSHION ASSEMBLY	SCALE
DE APPR.			NTS
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ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3781-043	ARMREST CUSHION ASSEMBLY
3	1	D3781-5	ARMREST CUSHION
4	1	D3785-1	BRACKET
6	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY
7	A/R	1300	3M SCOTCH-GRIP ADHESIVE



D3781-043 LATERAL ARMREST CUSHION BASE ASSY
(UPHOLSTERY FABRIC SHOWN PARTIALLY FOR CLARITY)

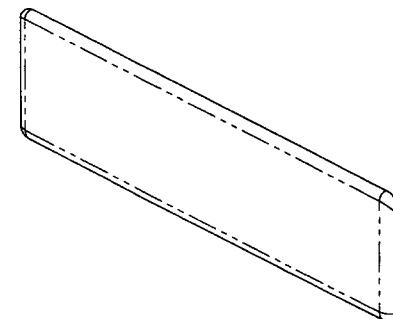
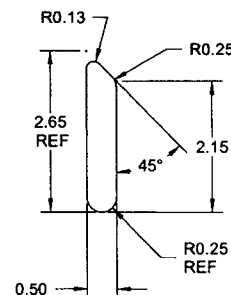
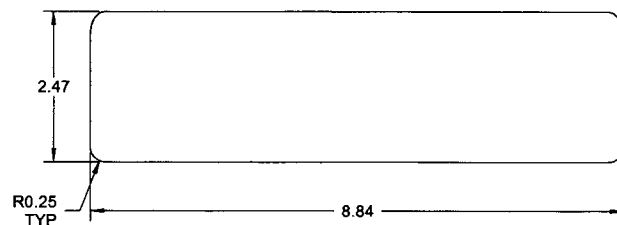
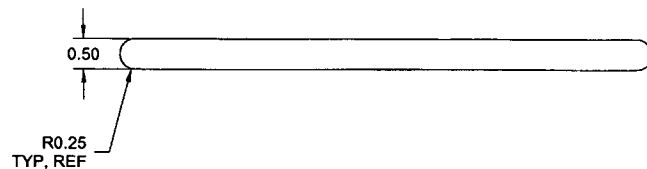
D3781-043 NOTES:

- 1) MATERIAL:
 - 1.1) SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
 - 1.2) THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
 - 1.3) ADHESIVE: 3M 1300/1300L
 - 1.4) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-043" USING FINE POINT PERMANENT INK MARKER AFTER RECEIVING
- 7) WEIGHT: 1.14 lbs
- 8) COVER D3781-5/D3785-1 ASSEMBLY WITH FABRIC (ITEM 6). BOND FABRIC TO PLATE USING ITEM 7 (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) DO NOT COVER HOLES WITH FABRIC

RELEASED
2010-04-26
MD

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3781 REV. E
MFG. APPR.		SHEET 3 OF 6
APPROVED		TITLE CUSHION ASSEMBLY SCALE NTS
DE APPR.		
DATE	10.04.14	

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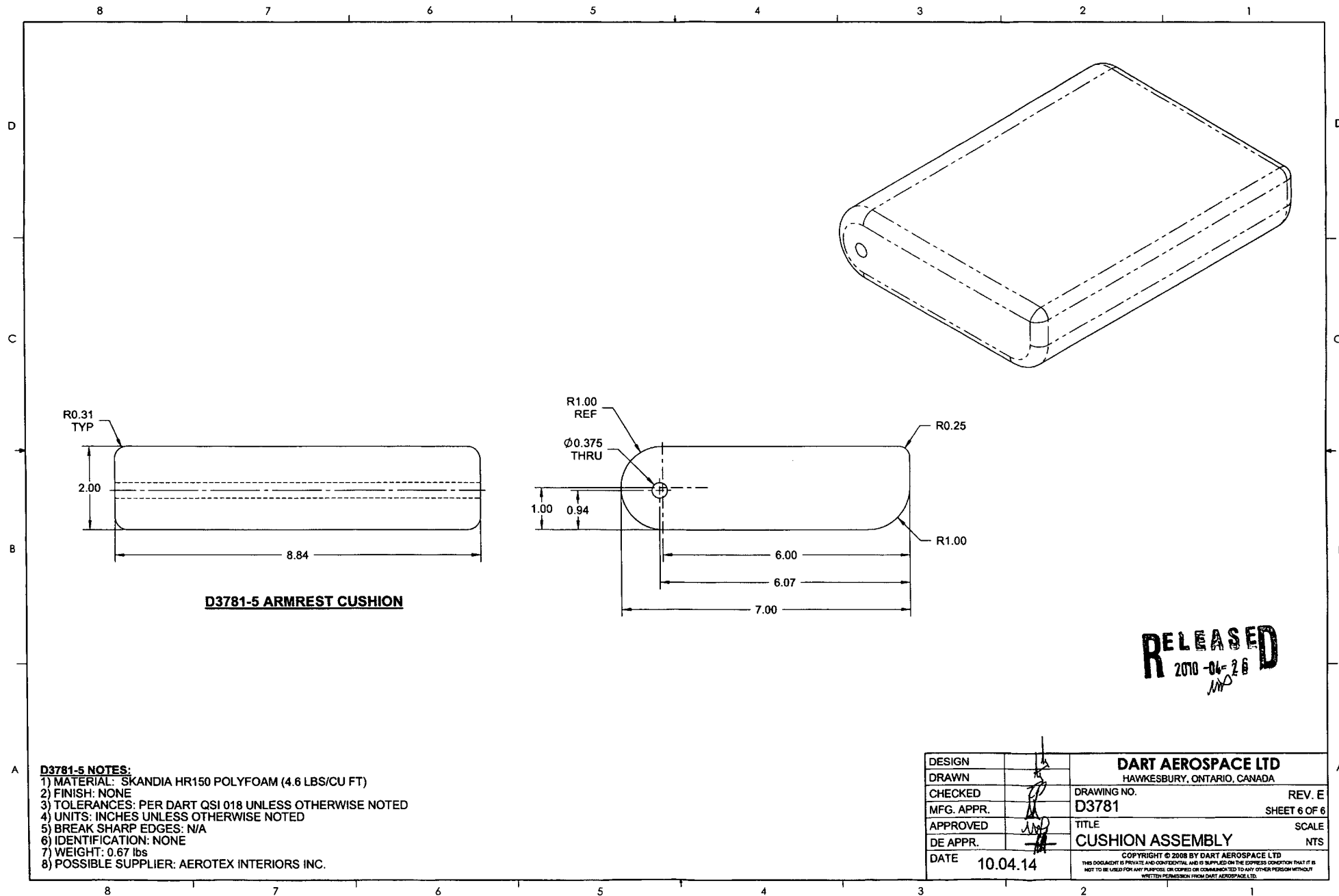
D3781-3 LATERAL CUSHION

D3781-3 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

RELEASED
2010-04-26
MP

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3781	REV. E
MFG. APPR.	<i>[Signature]</i>		SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CUSHION ASSEMBLY	NTS
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 2010-04-26
 MD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3781	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31772**

Purchase Order Date 3/22/2016

PO Print Date 3/22/2016

Page Number 1 of 2

Order From : VC-AER003

AEROTEX INTERIORS INC.
2340 PEGASUS WAY NE
UNIT 151
CALGARY, AB T2E 8M5
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
MAR 22 2016

Contact Name
Vendor Phone 403 295 8770

Ship To Contact
Ship To Phone
Ship Via: FedEx Economy collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3306-041P AS PER DWG D3306 REV. B B143678	Cover Assembly	3/30/2016 Yes 3/30/2016		6.00 Each	\$92.84	\$557.04
Line Total:							\$557.04
2	D3781-043P AS PER DWG D3781 REV. E B143653	Armrest Cushion Ass'Y	3/30/2016 Yes 3/30/2016		4.00 Each	\$259.93	\$1,039.72
Line Total:							\$1,039.72

C. L16103131

Note:

3/22/2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31772

Purchase Order Date 3/22/2016

PO Print Date 3/22/2016

Page Number 2 of 2

Order From : VC-AER003
AEROTEX INTERIORS INC.
2340 PEGASUS WAY NE
UNIT 151
CALGARY, AB T2E 8M5
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 403 295 8770

Ship To Contact
Ship To Phone
Ship Via: FedEx Economy collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

3	71401-45	PROCUREMENT QUALITY CLAUSES	3/30/2016	1.00	\$65.00	\$65.00
			Yes			
Procurement Quality Clauses			3/30/2016			
A004 faa-pma/tso						
A005 right of entry						
A016 personnel qualification						
A025 certification of conformance						
A040 notification of quality escape						
A041 quality management						
A042 dart noyification by supplier						
A043 retention of quality documents						

Line Total: \$65.00

PO Total: \$1,661.76

CLH

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 3/22/2016



151-2340 Pegasus Way NE
Calgary, AB T2E 8M5
PH: 403.295.8770 FX: 403.313.0793
EM: info@aerotex.ca WS: www.aerotex.ca

Ship: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA

Customer Phone
613.632.5200

Customer Fax
613.632.1053

Ship Via
FedEx P1

Courier Acct No.
151793240

#	Description
1	HEAD REST COVER WITH 3 VELCRO CLOSURE AS PER DWG D3306
2	ARMREST CUSHION ASSY.
3	Documentation Fee: Additional processing service for streamlining documentation and batch control into our AO 72-01. Release of Certification of Conformance. GST On Sales

Packing Slip

Date Packing Slip#

3/30/2016 16-205

Bill: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
CANADA

Email: dbates@dartaero.com

Ship Date P.O. No.

3/23/2016 P031772

PN	Qty	Ordered
D3306-041P	6 ✓	6
D3781-043P	4 ✓	4
71401-45	1 ✓	1

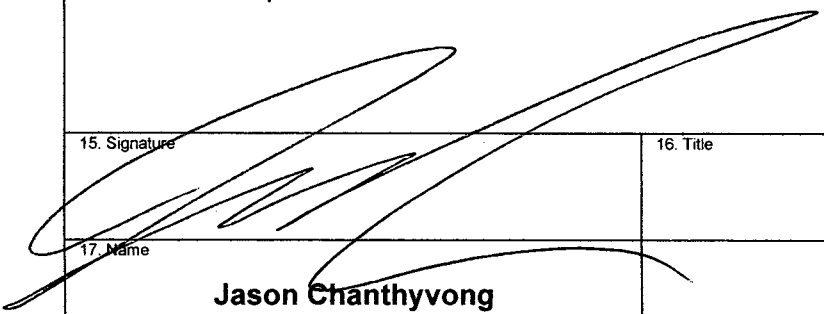
C216103131

Thank you for doing business with Aerotex Interiors!

GST/HST No.

139110308

"your one stop shop for all your aircraft interior needs"
www.aerotex.ca

Os 1. Organization issuing certificate. Aerotex Interiors Inc., #151-2340 Pegasus Way NE Calgary, AB T2E 8M5		2. CERTIFICATE OF CONFORMANCE					3. Work Order / Contract / Invoice 16-205	
4. Customer Name/Address DART Aerospace LTD 1270 Aberdeen Hawkesbury, ON K6A 1K7 CANADA							5. Purchase Order PO31772	
6. Unit	7. Materials Used for Items	8. Specifications	9. Batch	10. Item	11. Part Number	12. Quantity	13. Status	
1	FOAM	UC65	6307	Armrest Cushion Assembly	D3781-043P	4	NEW	
2	FABRIC – Surrey Silver	Surrey Silver	4935					
3	Thread – Nylon Thread	MIL-VT-295 TYPE II Class A	7665					
14. Remarks I certify that the materials supplied for the Purchase/Repair Order listed above conform to Aerotex Interiors' material/process specification and are in all respects in conformance with the contract requirements. I further certify that items have been fabricated to established specification to confirm with DWG. NO. D3781 Rev. E.								
15. Signature 			16. Title QC Manager					
17. Name Jason Chanthyvong			March 30, 2016					